DQA:	Da	te:		
		_	 	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

I	<u> </u>								QA Closed:	Date	:
Work Orde	er:				DISPOSITION	1	C1::4b.		PARÌMENT,	/PROCESS Water Jet	Engineering
Part N	lo				Rework Scrap	<u> </u>	Skid-tube Machining	Crosstube Small Fab	-4	d. Eng. Coor.	Quality
NCR N	lo		<u></u>		Use-as-is Work Order Update] The	rmoforming Large Fab	FinishingComposite	Rec/Stol	re/Packaging Supplier	Other
Root				Descr	iption of work order update	Initial	А	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief En	ng Des	cription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator		•									
Material		1									
Setup											
Other										5	;
Process						1	-				
Supplier	_										
Training											
Unapproved		l		l . <u></u>						<u>L </u>	
						AULT CAT	regory			_	
Landin F	ng Gear			-	General				ا د د د ح	[-	
}	Bending			_ -	Bend	Grain		<u> </u>	Ovalized		Pressure/Forced Temperature/Cure
}	Centre No	ot Concer	ntric to (^{0/\$} -	BOM/Route	Hard		-	Over/Under	F-	Weld
1	Cracks	اد د د د د د د		-	Broken/Damaged	Inspection Incomplete Part Incorrect Instructions Incomplete/Unclear Part Lost/Missing		<u> </u>	Wrong Stock Pulled		
}	Crushed/0	rimpea			Burrs	⊢ ⊣	itenance	- Cinclear	Part Moved	123111R	VVIOIR STOCK Fulled
}	Cuffs Contamination				-	\vdash	beled	 	Positioned \	Mrong	
}	Heat Treat Countersink		Cut Too Short	Misre			Power Loss,	· ·	Other		
Inspection Strip in Tube Cut Too Short Ripples in Bend Drill Holes				Offse		. L	الــــــــــــــــــــــــــــــــــــ		15000		
}	Torque W		ytrusini	<u>,</u> ├-	Drawing	├ ─┥	of Calibration			· · · · · · · · · · · · · · · · · · ·	
ł	Turning S			¨	Finish	\vdash	of Sequence				
ŀ	Wave/Tw	-		<u> </u>	Folio		de Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

100836

Work Order ID 100836

May 1, 2013 7:31:39 AM

Item ID:

D2366

Accept

Revision ID:

Item Name: ★
 Start Date:

Lock Handle

4/30/13

Start Qty: 12.00

12

Required Date: 4/30/13

Req'd Qty: 12.00

12

Reference:

Approvals:

Process Plan:

Date:

Tooling:

QC:

Date:

SPC (Y/N):

0.00

Sequelies as Work Center &

Operation Description

e = 60%Run Hours

130

130

Small Fab

Small Fab

0.00 Memo

Small Fab

Tumble and stock

Identify as per dwg & Stock Location: 57009

QC21- Final Inspection - Work Order Release

140

140

Packaging

Memo

0.00

0.00

0.00

0.00

Packaging

150

150

OC

Memo

Quality Control

Cust Item ID:

Customer:

Date:

N900040100

Date:

Run

Setup Start

Stop

NS2

Stop

Tool ID

Too!# Plan Code

Reject Accept Qty Qty

Reject

hisp.

Number Stamp

12 7613-7-31

12x M.N. 13-08-6

MLJ 13-08-07

MUJ 130806

			DQA:	Date:	
				-	
ICD:	Vac. / No	WORK ORDER NON-CONFORMANCE / LIPDATE			

		, 110									QA Closed:	Date	e:
Work Ord	er.		—:		-	DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
						Rework	7	Skid-tube Crosstube		Water Jet	Engineering		
Part f	۷o.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is	1		noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR I	۷o.					Work Order Update]		Large Fab	Composite]	Supplier	
							اا	L					
Root						ption of work order update	1	nitial		tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data		·											
Equip/Tooling				1									
Operator		!											
Material	_		1						İ				
Setup		<u> </u>			İ				:				
Other	L_	4											
Process		1		•			1		<u> </u>				
Supplier	_	1		<u> </u>									
Training	_				! 					•			
Unapproved	_		<u> </u>		<u> </u>								
							AUL	T CATE	GORY				
Landi	ng (3				General		ا ما			٦	Г	
	<u> </u>	Bending	_			Bend	-	Grain		<u> </u>	Ovalized		Pressure/Forced
	<u> </u>	Centre No	ot Concer	ntric to	o/s	BOM/Route	-	Hardwa			Over/Under	ŀ	Temperature/Cure Weld
	_	Cracks			<u> </u>	Broken/Damaged	_	1	ion Incomplete		Part Incorre	ŀ	
	_	Crushed/0	Crimped.		-	Burrs	-	1	tions Incomplete/	Unclear	Part Lost/M	issing [Wrong Stock Pulled
	<u> </u>	Cuffs	_		<u> </u>	Contamination	_	Mainte		<u> </u>	Part Moved	t dua mar	
! ├─┪ ├──┪		Countersink	\vdash	Mislabe		-	Positioned V		Other				
	\vdash	Inspection		Tube	-	Cut Too Short	—	Misrea	Di .		Power Loss/	ouige [Comer
	<u> </u>	Ripples in			-	Drill Holes		Offset	Calibantina				<u> </u>
	<u> </u>	Torque W			n	Drawing	\vdash	1	Calibration				
	•	Turning Se	equence		1	Finish	1	Out of :	Seguence				

Outside Dimensions

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID:

100836

Parent Item:

D2366

Parent Item Name:

Lock Handle

Comments:

M304S20GA

IPP B00.05.04ReformatEC

IPP Rev:C Now on Waterjet 07-04-20 JLM

Component Item ID/ Item Name

304/316 .040 Sheet

Replacement Item ID

Mfg/ Purch

Purchased

Bin Item

No

Primary Location Last Location

Unit of Route Seq ID

Measure Hand sf

327.9000

Qty on

0.0174

Start Date: 4/30/13

Start Qty: 12.00

Qty

Qty per Kit Total

0.2197896 0.35

JM13-07-25

Required Date: 4/30/13

Required Qty: 12.00

Qty

Issued

Location MATuzi

. .:ng 120250 Loc Qty

100

. 15 210.75 Loc Code

Date Status Issued

Page 1

		DQA:	Date:	
				~
 1	WORK ORDER NON CONFORMANCE / LIDDATE			

NCR:	NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE											
										QA Closed:	Date:	
Work Order:					DISPOSITION			AGAINST D	DEPARTMENT,	/PROCESS		
Part I	•		· · · ·			Rework Scrap		Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR I	•					Use-as-is Work Order Update	The	rmoforming Large Fab	Finishing Composite	- -	re/Packaging Supplier	Other
Root					Descri	ption of work order update	Initial	A	ction	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Chief En	g Des	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved									·			
							AULT CAT	EGORY				
Landi	ng (l				General	<u></u>		٦	-		٦
	<u> </u>	Bending				Bend	Grain		-	Ovalized	<u> </u>	Pressure/Forced
	\vdash	Centre No	ot Conce	ntric to	O/S -	BOM/Route	Hardy			Over/Under		Temperature/Cure
	-	Cracks			-	Broken/Damaged	\vdash	ction Incomplete	(the sleep	Part Incorre	<u></u>	Weld Wrong Stock Pulled
		Crushed/	Crimped		-	Burrs		ctions Incomplete	Junciear	Part Lost/M		Tanigus prock Lausea
	\vdash	Cuffs			<u> </u>	Contamination	\vdash	tenance	-	Part Moved		
	1	Heat Trea	at .			Countersink	Misla	peled		Positioned \	wrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

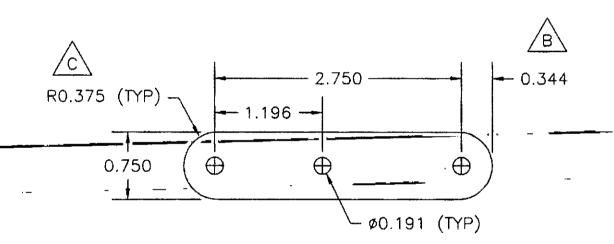




DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. REV. O
DATE		TITLE SCALE
00.04.24		LOCK HANDLE 1:
Α	95.02.20	NEW ISSUE
8	96.06.10	R0.50 WAS R0.354; 0.344 WAS 0.300
С	00.04.24	R0.375 WAS R0.50



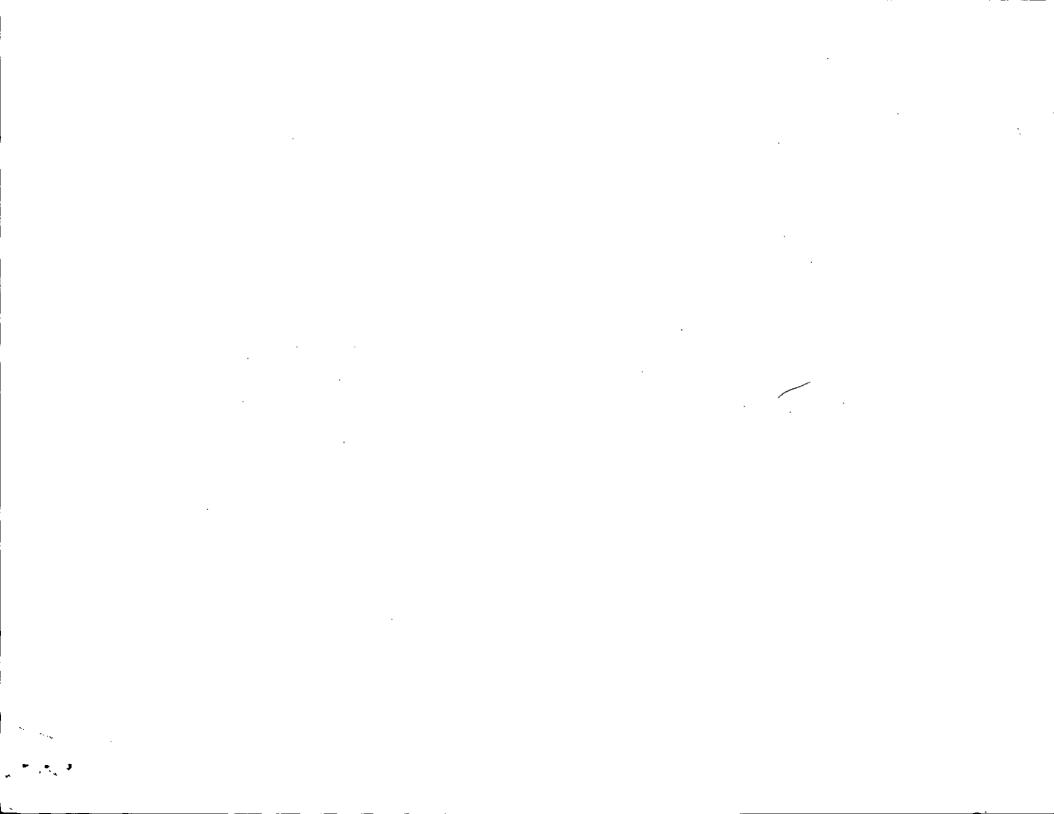
100834 pl 13-05-1



MATERIAL: AISI 304/316 SS 0.040 THICK TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED ALL DIMENSION ARE INCHES

Copyright © 1995 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DART AEROSPACE LTD	Work Order:	100836
Description: Lock Handle	Part Number:	D2366
Inspection Dwg: D2366 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
-----------------	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.191	+0.005/-0.001	0.192"			V	JLMOI
0.750	+/-0.010	0.754°	_		V	
0.344	+/-0.010	0.348	_	-	V	,
1.196	+/-0.010	1.198"	_		V	
2.750	+/-0.010	2.753"	-		V	
					Ţ	· :
			<u>-</u>			
_			_			
2-8					· .	
					·	
,						
:						
						-
· .					,	
		<u> </u>	040			

Measured by: Jm Audited by: 27 Prototype Approval: N/A

Date: 13-07-25 Date: 13 7 26 Date: N/A

Rev	Date	Change	 Revised by	Approved
A	08.02.28	New Issue	 KJ/DD of	13
			 - (x)	

•

.